

Date: Monday, 07/04/2008 11:47:05 AM
User: Julie Lecocq

Process Sheet

| | | | | | | | |
|----------------------------------|---|-----------------|-------------------|-------------------------|-----------------|-------------|---|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : AFT CROSSTUBE | | |
| Job Number | : 38426 | | | Part Number | : D2890 | | |
| Estimate Number | : 10377 | | | Drawing Number | : D2890 REV B | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 07/04/2008 | S.O. No. | : | Drawing Revision | : B | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / | Type | : PURCHASED PARTS | Due Date | : 10/05/2008 | Qty: | 1 |
| Previous Run | : 38425 | | | Um: | : Each | | |
| Written By | : <u>JKO</u> 08.4.00 | | | | | | |
| Checked & Approved By | | | | | | | |
| Comment | : Est. D 05.03.21 Removed Bending procedures KJ/JLM | | | | | | |

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 D6008180 Crosslube extrusion

• Qly..

| Qty | Part # | Description |
|-----|-----------|---------------------|
| 1 | D6008-180 | Crosstube extrusion |

Batch

30 RENDI

BENDING MACHINE SKID TUBES

Comment: BENDING MACHINE

1-Bend D2890 as per Dwg D2890 and Folio FT002

3.0 QC6

~~DIMENSIONAL CHECK~~

Comment: DIMENSIONAL CHECK

4.0 SKIDTUBES 1

SKIDTUBES RESOURCE 1

Comment: LANDING GEAR RESOURCE 1

1-Deburr and Polish

5.0 HAND FINISHING 1

~~HAND FINISHING RESOURCE #1~~

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per OSI 005.4.1

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CROSSTUBE

Job Number: 38426

Part Number: D2890

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W10 40738

(-107)

08-07-24 (0)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/24 (0)

Comment: FINAL INSPECTION/W/O RELEASE

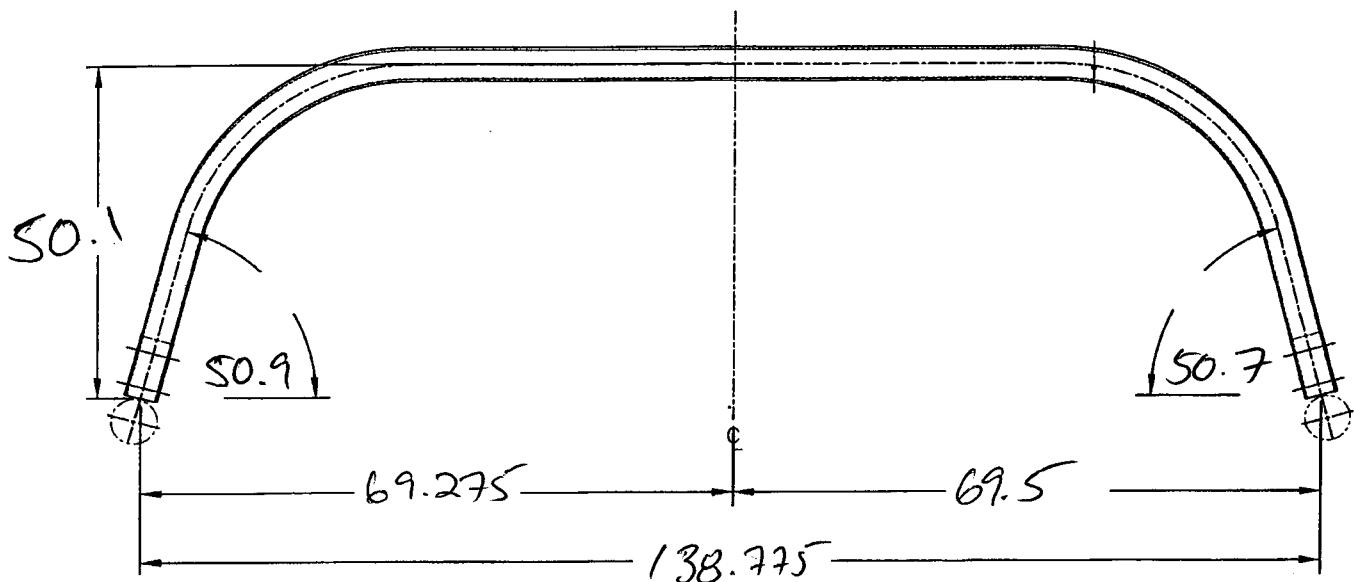
Job Completion



mf 08-07-24

| | | |
|----------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 38426 |
| Description: Crosstube Aft | Part Number: | D2890 |
| Inspection Dwg: D2890 | Rev: B | Page 1 of 1 |

| Required Dimension | Min | Max |
|--------------------|--------|--------|
| Height | 49.875 | 50.125 |
| 1/2 Span | 69.275 | 69.525 |
| Angle | 49 | 52 |
| Total Span | 138.55 | 139.05 |



| Comments |
|----------|
| |
| |
| |

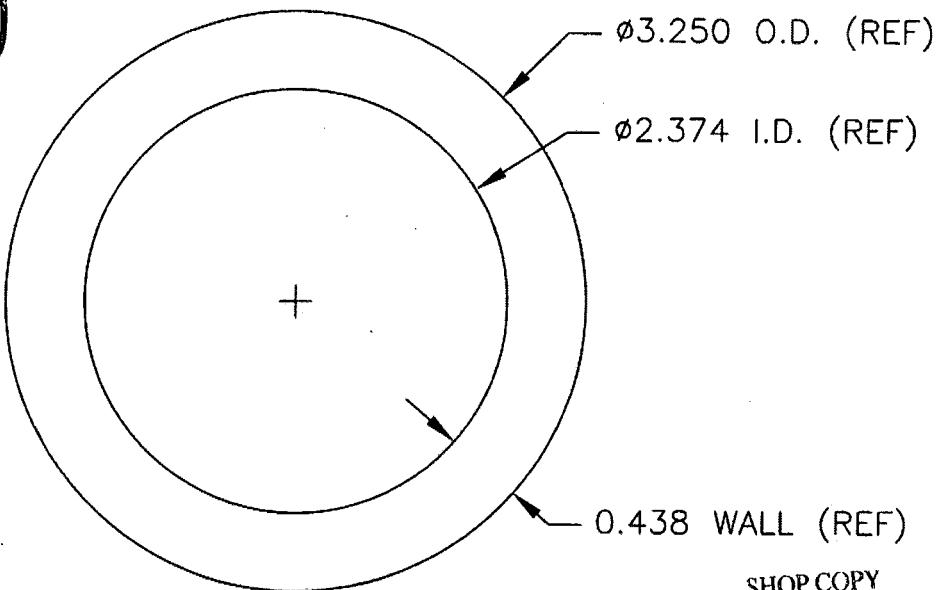
| | |
|-----------------|------------|
| QC15 Inspection | |
| Date | 08/04/2004 |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 07.02.06 | New Issue | KJ/JM | JM |

DART

| | | |
|----------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D6008 |
| DATE | | REV. A SHEET 1 OF 1 |
| 00.11.17 | | TITLE CROSSTUBE MATERIAL |
| A | 00.11.17 | SCALE 1:1 NEW ISSUE |

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24NOTES

1) D6008-XXX CROSSTUBE

LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008-180

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38426

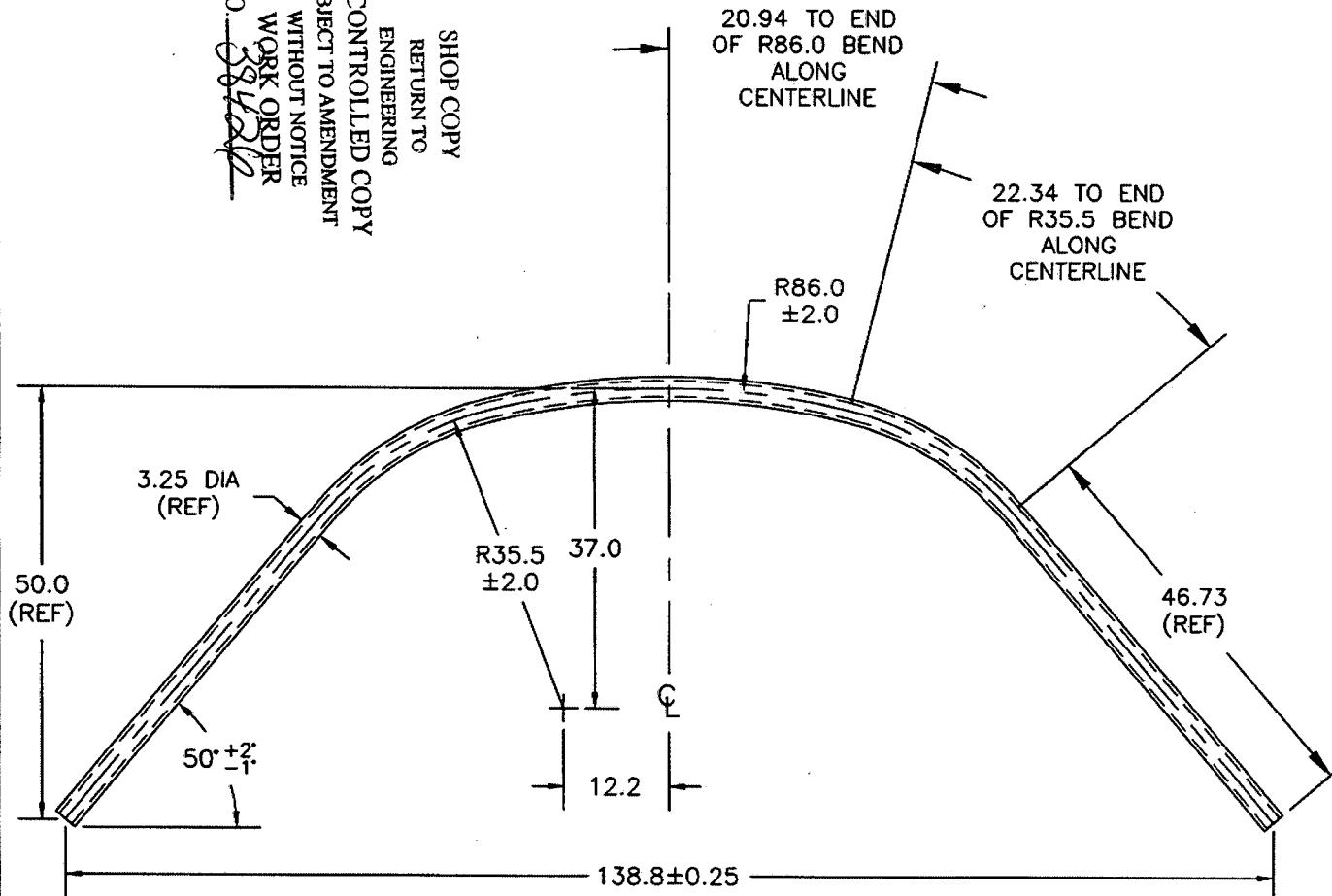
- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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DART**DART**
02.10.28**RELEASED**

| | | | |
|----------|---------------|-----------------------------------|--------------|
| DESIGN | DRAWN BY | DART AEROSPACE LTD | |
| | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. | REV. B |
| | | D2890 | SHEET 1 OF 1 |
| DATE | TITLE | | SCALE |
| 02.10.18 | AFT CROSSTUBE | | 1:20 |
| A | 99.05.21 | | |
| B | 02.10.18 | ADD TANGENT LENGTHS; CHANGE NOTES | |

**NOTES**

- 1) MATERIAL: MANUFACTURE FROM D6008-180 ($\varnothing 3.25$ OD x 0.438 WALL)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BEND PROGRESSIVELY WITH MINIMUM OF 3 PASSES
- 6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.